

Work Order ID 61049

Wednesday, August 04, 2010 1:07:41 PM

Page 1

Item ID: D3684-047

Accept

Setup Start

Revision ID:

Stop

Item Name: FWD LEG ASS'Y

Start Date: 8/4/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 8/11/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *mf* Date: *10-8-04*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3684

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

**Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

sn 10/07/05

(1)

sn 10/08/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/08/05

(+1)

130



Packaging

Packaging

Identify as per dwg & Stock Location: GA.

0.00

Memo

0.00

ME 10-8-05

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/06

ME 10-8-05

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NOTE: Date & initial all entries

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Work Order ID: 61049

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y



Start Date: 8/4/2010

Start Qty: 1.00

Required Date: 8/11/2010

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|----------------|----------------|---------------|----------------|--------|
| AN3C12A | | Purchased | No | | | 110 | Each | 32.0000 | 2 | 2 | | | |
| Bolts | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | | | <u>Loc Qty</u> | | | |
| | | | | ST351 | | | | | | 32 | | | |
| | | | | 112314 | | | | | | 8 | | | |
| | | | | 114761 | | | | | | 11 | | | |
| | | | | 115016 | | | | | | 13 | | | |
| D3688-1 | | Manufactured | No | | | 110 | Each | 11.0000 | 1 | 1 | | | |
| STUD | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | | | <u>Loc Qty</u> | | | |
| | | | | ST075 | | | | | | 11 | | | |
| | | | | 58635 | | | | | | 5 | | | |
| | | | | 59668 | | | | | | 6 | | | |
| D3689-1 | | Manufactured | No | | | 110 | Each | 14.0000 | 1 | 1 | | | |
| SLEEVE | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | | | <u>Loc Qty</u> | | | |
| | | | | ST082 | | | | | | 14 | | | |
| | | | | 56335 | | | | | | 1 | | | |
| | | | | 58634 | | | | | | 13 | | | |

SN 10/08/05

SN 10/08/05

SN 10/08/05

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Work Order ID: 61049

Parent Item: D3684-047


Parent Item Name: FWD LEG ASS'Y

Start Date: 8/4/2010


Required Date: 8/11/2010

Start Qty: 1.00


Required Qty: 1.00

D3691-1

 Manufactured No 110 Each 16.0000 1 1
 STUD


| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST082 | 16 | |
| 58631 | 16 | |

D3692-1

 Manufactured No 110 Each 401.0000 4 4
 SPACER

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST082 | 401 | |
| 50736 | 10 | |
| 51467 | 391 | |

D3693-1

 Manufactured No 110 Each 41.0000 1 1
 Rod End Bearing

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST082 | 41 | |
| 50734 | 41 | |

MS21043-3

 Purchased No 110 Each 2,937.000 2 2
 Nut

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG | 76 | |
| 103691 | 76 | |
| ST301 | 2861 | |
| 112314 | 2861 | |

1 10/03/05
 4
 7 10/03/05
 1
 2 10/03/05
 2 10/03/05

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Work Order ID: 61049



Parent Item: D3684-047



Parent Item Name: FWD LEG ASS'Y

Start Date: 8/4/2010

Required Date: 8/11/2010

Start Qty: 1.00

Required Qty: 1.00

NAS509-12C

Purchased

No

110

Each

47.0000

1

1



Nuts

Location

Loc Qty

Loc Code

ST280

47

112453

47

NAS509L12C

Purchased

No

110

Each

52.0000

1

1



Nuts

Location

Loc Qty

Loc Code

ST280

52

112314

42

112828

10

1 8/5 10/08/05

1 8/5 10/08/05

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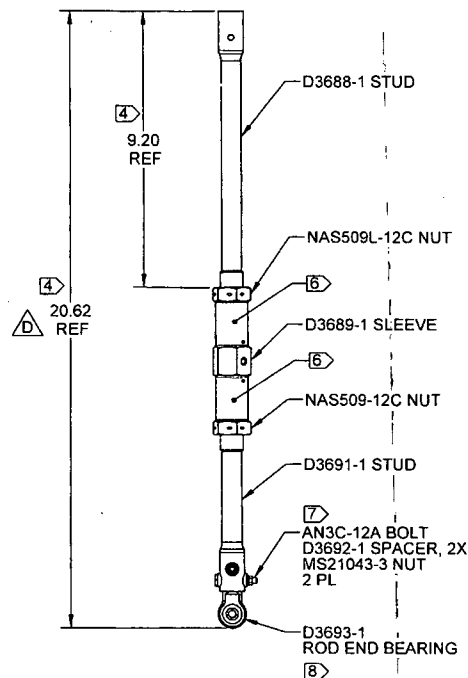
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NOTE: Date & initial all entries

| ITEM | QTY -047 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|------------------|
| 1 | X | D3684-047 | FWD LEG ASSEMBLY |
| 2 | 1 | D3688-1 | STUD |
| 3 | 1 | D3689-1 | SLEEVE |
| 4 | 1 | D3691-1 | STUD |
| 5 | 4 | D3692-1 | SPACER |
| 6 | 1 | D3693-1 | ROD END BEARING |
| 7 | 2 | AN3C-12A | BOLT |
| 8 | 2 | MS21043-3 | NUT |
| 9 | 1 | NAS509L-12C | NUT |
| 10 | 1 | NAS509-12C | NUT |



D3684-047 FWD LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.09 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>[Signature]</i> | D3684 | SHEET 4 OF 5 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TRIPOD MOUNT ASSY | NTS |
| DATE | 10.03.03 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

RELEASED
2010-03-15

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